

6061 R0.500"

Work Order ID 79593

January-30-12 7:03:42 AM

79593

Page 1

Item ID: D4170-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 1/30/12

Start Qty: 24.00

24

Cust Item ID:

Required Date: 2/01/12

Req'd Qty: 24.00

24

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4170

B

100

0.00

100

Hardinge CNC LATHE SMALL

24

0

B.A. / 12/02/2012

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

Machine as per Folio FA989

FOLIO REV: NADWG REV: B

DEBURR

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

24

0

B.A. / 12/02/2012

QC

Memo

0.00

Quality Control

Work Order ID 79593

79593

Page 2

January-30-12 7:03:42 AM

Item ID: D4170-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 1/30/12 Start Qty: 24.00

24

Cust Item ID:

Required Date: 2/01/12 Req'd Qty: 24.00

24

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
125		0.00							
125									
Skidtubes	Memo	0.00							
Skidtubes	1- clean crossbolt spacer with ultra brigh aluminum cleaner before storing.								
130	Identify as per dwg & Stock Location: LG	0.00							
130									
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								

(24) 12-02-28

24 8 BE 12/2/29

Work Order ID 79593***79593***

Page 3

January-30-12 7:03:42 AM

Item ID: D4170-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bushing

Start Date: 1/30/12 Start Qty: 24.00

24

Cust Item ID:

Required Date: 2/01/12 Req'd Qty: 24.00

24

Customer:

Reference:

Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ 12/02/29

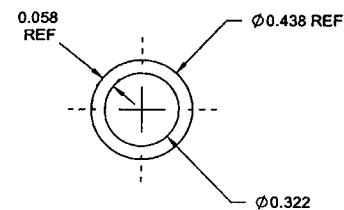
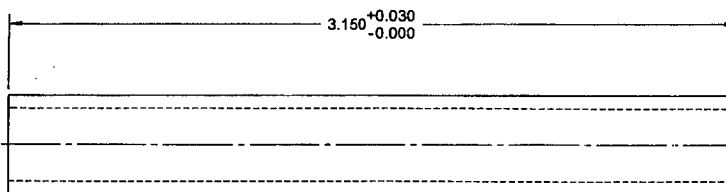
MLJ 12/02/29
(24)

January-30-12 7:03:42 AM

Required Qty: 24.00

6.6304

FIRST ARTICLE INSPECTION CHECKLIST



D4170-3 SPACER

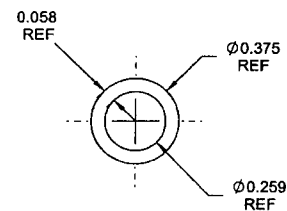
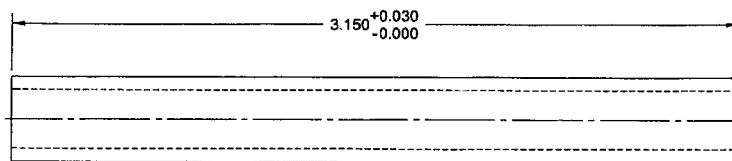
NOTES:

- 1) MATERIAL: 6061-T6 ROUND BAR, $\phi 7/16$ OD
PER QQ-A-225/8, QQ-A-200/8, ASTM B211, OR ASTM B221
REF DART SPEC. M6061T6R0.438
OR
6061-T6 OR 6061-T62 TUBING, $\phi 7/16$ OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.438W.058
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

w/b
79593

RELEASE
2010-11-01

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	96	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4170	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SPACER	NTS
DATE	10.10.25	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D4170-1 SPACER

RELEASED
2010-11-01

no 79593

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING, ϕ 3/8 OD X 0.058 WALL
PER WW-T-700/6, AMS 4080, AMS 4082, QQ-A-200/8, OR QQ-A-225/8
REF DART SPEC. M6061T6T0.375W.058
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01lbs

B	ADD-3 (SHEET 2)	CP	10.10.25
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D4170 TITLE SPACER SCALE NTS	
DRAWN	<i>g</i>		
CHECKED	<i>g</i>		
MFG. APPR.	<i>g</i>		
APPROVED	<i>g</i>		
DE APPR.	<i>g</i>	REV. B	
DATE	10.10.25	SHEET 1 OF 2	

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